

20-8463



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2600-3-BENT-RH
Job Sheet 212300



Part No: D2600-3-BENT-RH

Job Qty: 6 pcs

Part Name: Extrusion Bent RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/19/20

Job Tracking No:

Due Date: 9/11/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D2750 REV.H SHEET 4, D2600 REV.E SHEET 2 IPP REV:A 14.01.14 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time		
100	Skid tubes - Bend - 1	6 pcs	9/11/20	9/11/20	0.23	2.99	Skid tubes - Bend		03	20.9.2
110	QC 5	6 pcs	9/11/20	9/11/20	0.00	0.00	QC 5 - 10		03	20.9.2
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			
							QC 5 - 50			
							QC 5 - 30			
							QC 5 - 40			
							QC 5 - 61			
							QC 5 - 81			
							QC 5 - 82			
120	Packaging 3-1 - Stock - B4B	6 pcs	9/11/20	9/11/20	0.00	0.00	Packaging 3 - 1 - B4B			
							Packaging 3 - 2 - B4B			
							Packaging 3 - 3 - B4B			
							Packaging 3 - 4 - B4B			
							Packaging 3 - 5 - B4B			
							Packaging 3 - 6 - B4B			
							Packaging 3 - 7 - B4B			
							Packaging 3 - 8 - B4B			
							Packaging 3 - 9 - B4B			
							Packaging 3 - 10 - B4B			



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Container No: S297958



Part: D2600-3-BENT-RH

Job No: 212300

Serial No/Batch: S297958

Revision: REV.H/ E

Inspector:

Exp Date:

Instructions:

Date: 05/02/20

				Packaging 3 - 11 - B4B					
				Packaging 3 - 12 - B4B					
				Packaging 3 - 13 - B4B					
				Packaging 3 - 14 - B4B					
				Packaging 3 - 15 - B4B					
				Packaging 3 - 16 - B4B					
				Packaging 3 - 17 - B4B					
				Packaging 3 - 18 - B4B					
				Packaging 3 - 19 - B4B					
				Packaging 3 - 20 - B4B					
				Packaging 3 - 21 - B4B					
				Packaging 3 - 22 - B4B					
				Packaging 3 - 23 - B4B					
				Packaging 3 - 24 - B4B					
				Packaging 3 - 25 - B4B					
				Packaging 3 - 26 - B4B	BE 20-09-23				
				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					
				Packaging 3 - 30 - B4B					
				Packaging 3 - 31 - B4B					
				Packaging 3 - 32 - B4B					
				Packaging 3 - 33 - B4B					
				Packaging 3 - 34 - B4B					
				Packaging 3 - 35 - B4B					
				Packaging 3 - 36 - B4B					
				Packaging 3 - 37 - B4B					
				130 QC 21 - SA	6 pcs	9/11/20	0.00 0.00	QC 21 - SA - 21	
								QC 21 - SA - 70	
								QC 21 - SA - 9	
								QC 21 - SA - 77	
				Part Op 100 - (CNC Delta 100 Bender) Pick qty 1 D2600-3-130 extrusion 1-Deburr one end of extrusion 2-Bend using CNC Descriptions: bending machine as per program 2750.C and Folio 14 use bending aid DT9635 3- cut fwd end of tube as per dwg D2750 4- cut aft end of tube as per dwg D2750 110 - (QC5- Inspect part completeness to step on W/O) 120 - (Identify as per dwg & Stock Location: LG002) LOCATION : LG002 130 - (QC21- Final Inspection - Work Order Release)					
				Job BOM					
				Part / Item	Component Name	Quantity	Operation	Container	
				D2600-3-130	Extrusion Round 3" 350	6 pcs (1 ea)	100-Skidtubes - Bend - 1	5214450	
				Job Allocations					
				Operation	Component Part	Required	Inventory	Allocated	
100-Skidtubes - Bend - 1	D2600-3-130	6	96	0					
Part Specifications									
Specifications could not be found.									

Plex 8/19/20 1:42 PM Dart.lajeunesse.marie

QTY -041	QTY -042	QTY -043	QTY -044	QTY -051	QTY -052	P/N	DESCRIPTION
X						D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X					D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X				D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X			D2750-044	350 SKIDTUBE ASSEMBLY, RH
				X		D2750-051	350 SKIDTUBE ASSEMBLY, LH
					X	D2750-052	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	1	1	D2739	WEB
8	8	8	8	8	8	D2743	CROSS BOLT SPACER
1	1	1	1	1	1	D2744	CAP
8	8	8	8	8	8	D2745	BUSHING
1						D2750-1	350 SKIDTUBE ASSEMBLY
	1					D2750-2	350 SKIDTUBE ASSEMBLY
		1				D2750-3	350 SKIDTUBE ASSEMBLY
			1			D2750-4	350 SKIDTUBE ASSEMBLY
				1		D2750-5	350 SKIDTUBE ASSEMBLY
					1	D2750-6	350 SKIDTUBE ASSEMBLY
1		1		1		D3488-3	BLADE FITTING, LH
	1		1		1	D3488-4	BLADE FITTING, RH
4	4	4	4			D3490-1	CROSS BOLT SPACER
4	4					D3490-3	CROSS BOLT SPACER
		4	4			D3490-5	CROSS BOLT SPACER
8	8	8	8			D3492-041	PLUG
8	8					D3492-043	PLUG
		8	8			D3492-045	PLUG
3	3	3	3	3	3	D3537-1	WEARPAD
8	8	8	8	8	8	D3631-1	WASHER
1	1	1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	1	1	D3793-5	WEARSHOE
38	38	38	38	38	38	ALS4-1032-225	INSERT
				1	1	AN3C34A	BOLT
34	34	34	34	34	34	AN3C5A	BOLT
4	4	4	4	4	4	AN3C6A	BOLT
4	4	4	4	4	4	AN8C44A	BOLT
1	1	1	1	1	1	AN8C35A	BOLT
				1	1	MS21043-3	NUT
4	4	4	4	4	4	MS21043-6	NUT
1	1	1	1	1	1	MS21083C8	NUT
38	38	38	38	38	38	NAS1149C0332R	WASHER
				2	2	NAS1149C0363R	WASHER
1	1	1	1	1	1	NAS1149C0632R	WASHER
4	4	4	4	4	4	NAS1815H3L	WASHER

NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4/-5/-6 FROM D2800-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB. STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2. OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3. BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.1 lbs
D2750-051/-052 = 25.7 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 19/64" SIZE HOLES ($\phi 0.287$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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H	ADDED -051/-052 (ZN D5-1 SHEETS 4, 15-16); ADDED D2750-041/-042 (ZN C5-1 SHEETS 9, 10); D3488-3/4 REPLACES D3488-041/-042 (ZN C5-1, D2-1/-12/-13/-14); D3793-5 REPLACES D3536-25 (ZN B6-1, C4-1/-12/-13/-14); NAS1149C0332R REPLACES AN80C10L (ZN A5-1, B1-1/-12/-13/-14, C7-1/-12/-13/-14); NAS1149C0632R REPLACES AN80C216L (ZN A5-1, C1-1/-12/-13/-14); REMOVED D3784-1/3, AND D3536-25 GASKETS	ZF	18.03.05
G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS +0.01/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4-6-8-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-278 AND NCR13-2787	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3532-13/35 (ZN C8-1); D3794-1/3 REPLACES D3532-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 06-045	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1815H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN80C216; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 0133/0157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2736 AND D2740	CP	98.11.18
B	CHANGE MS24694-S283 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
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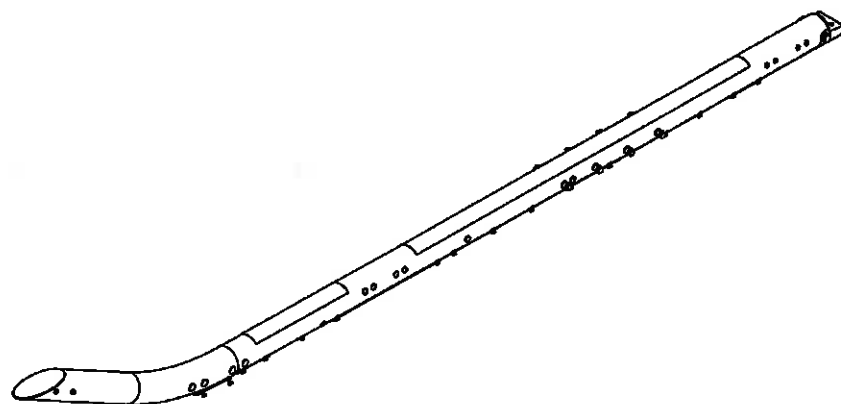
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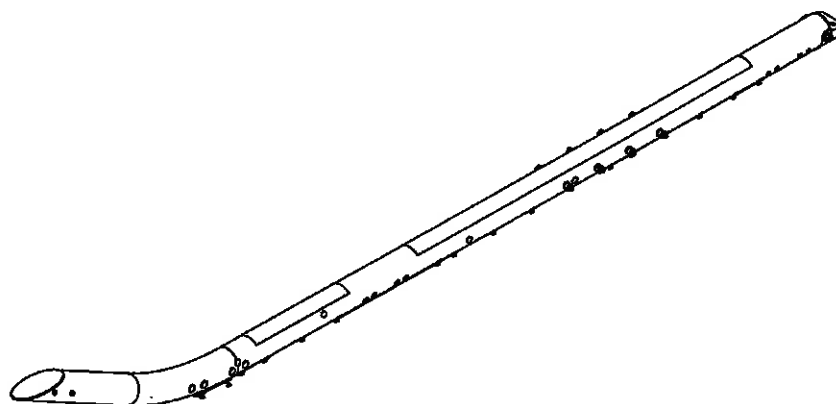
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A

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D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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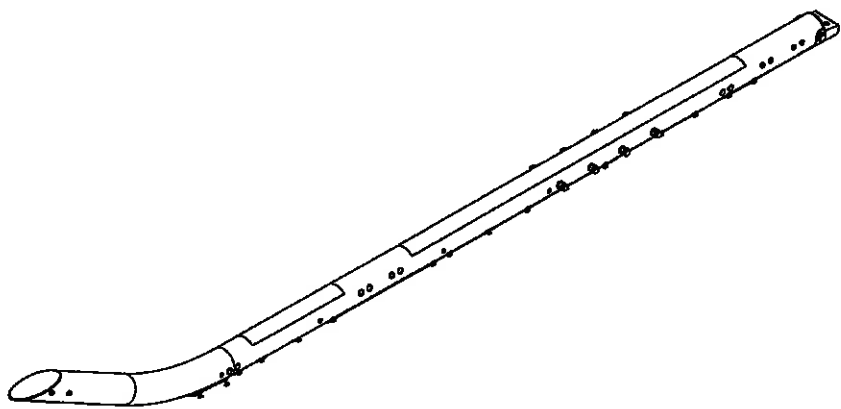
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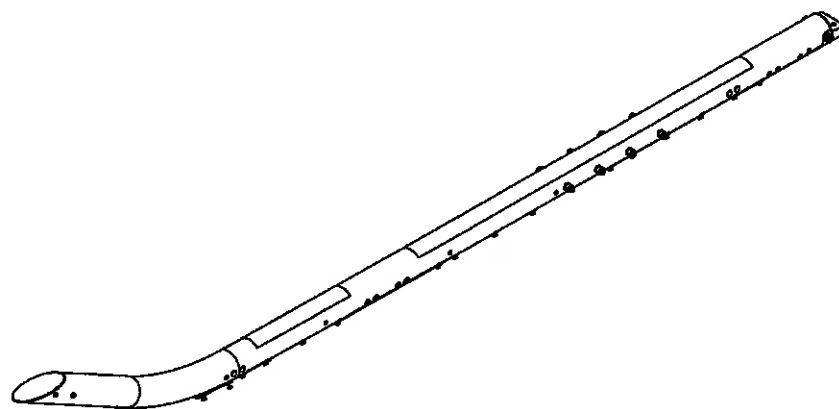
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D2750-043 350 SKIDTUBE ASSEMBLY, LH



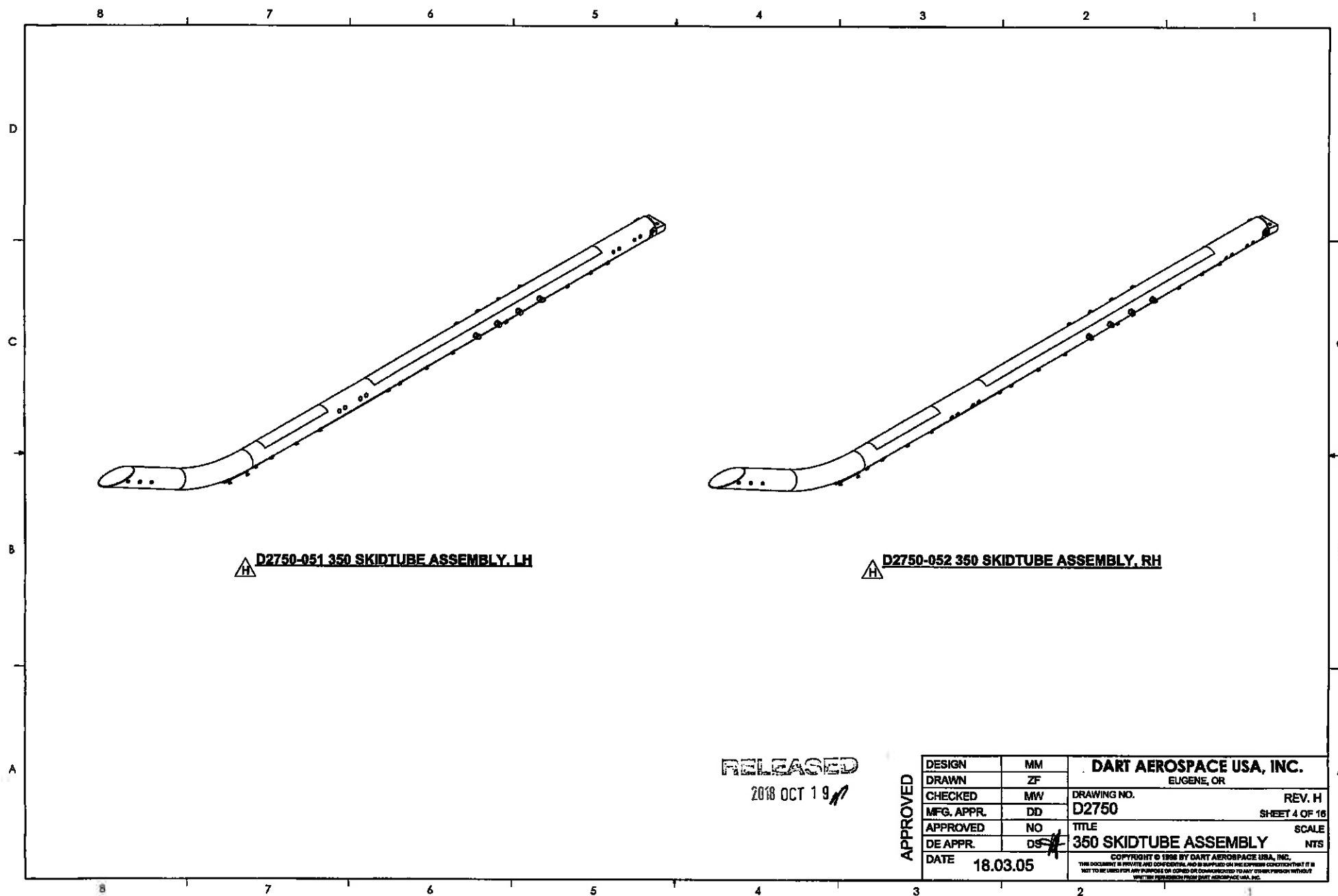
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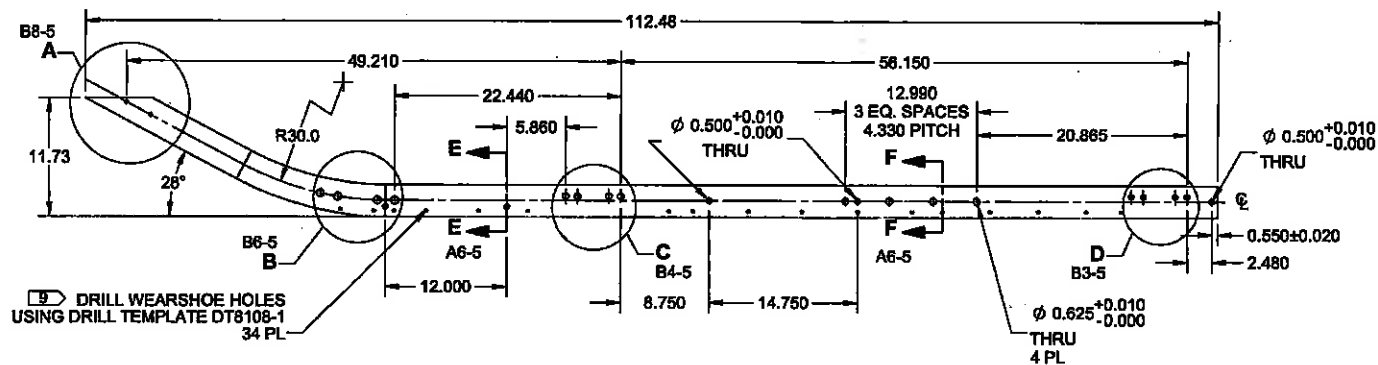
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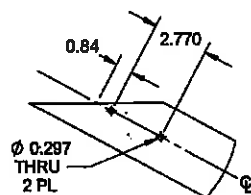
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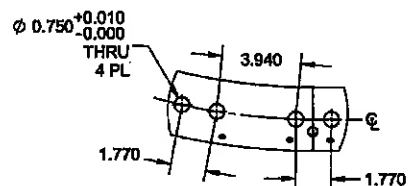




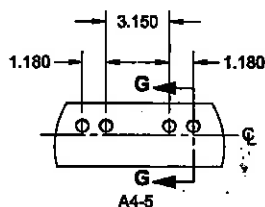
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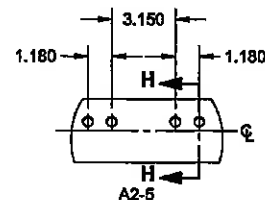
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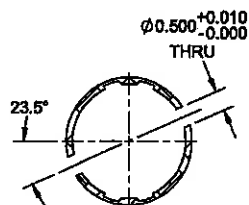
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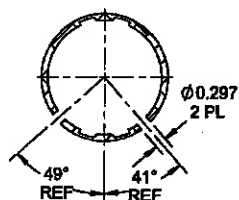
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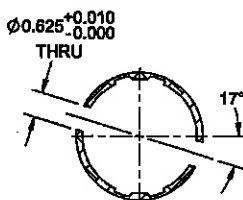
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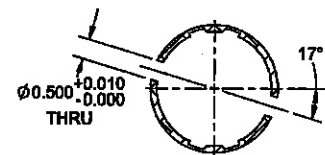
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SECTION F-F
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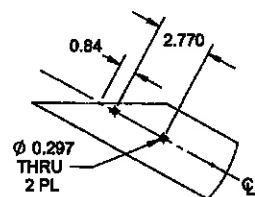
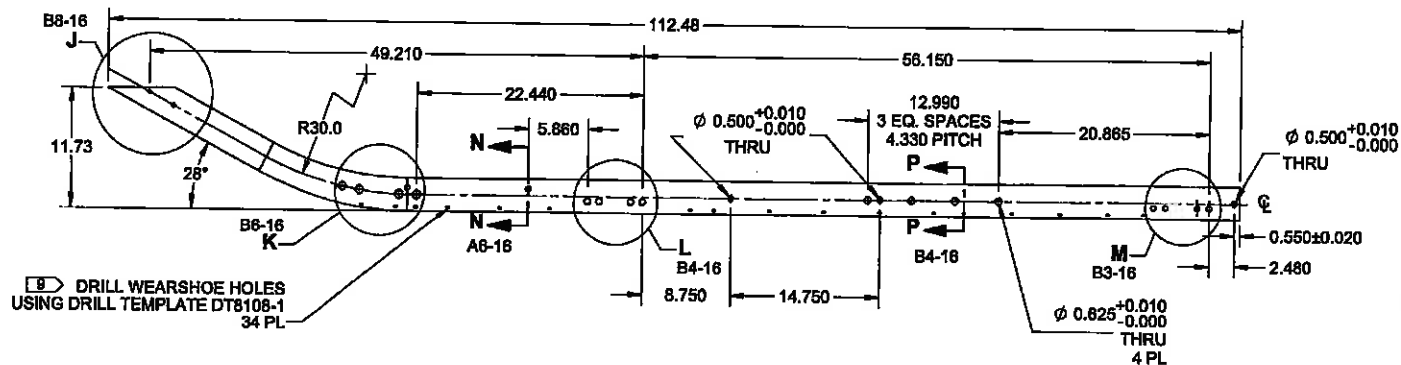
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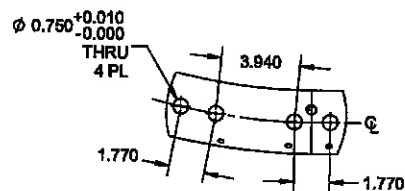
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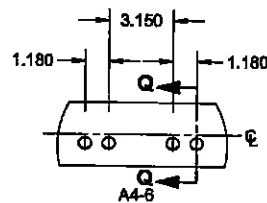
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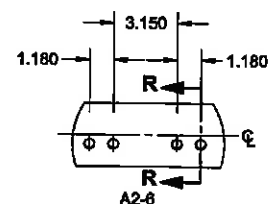
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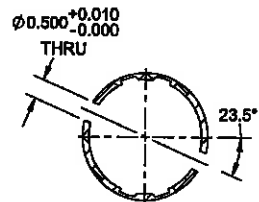
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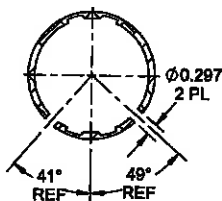
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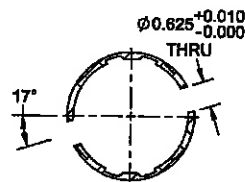
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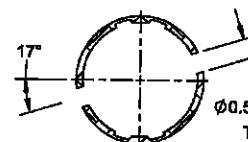
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SECTION P-P
SCALE 4X, 17 PL



SECTION Q-Q
SCALE 4X, 4 PL



SECTION R-R
SCALE 4X, 4 PL

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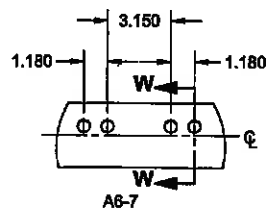


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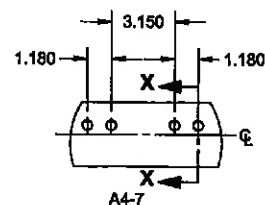
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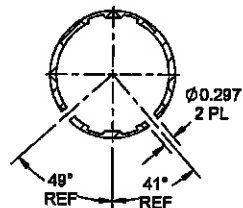
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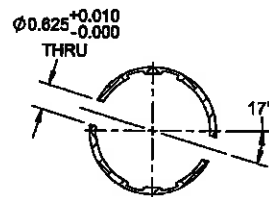
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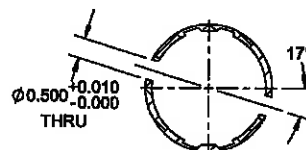
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D4-7
SECTION V-V
SCALE 4X, 17 PL



B6-7
SECTION W-W
SCALE 4X, 4 PL



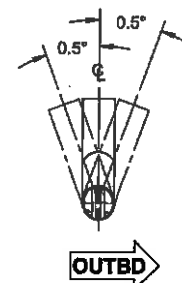
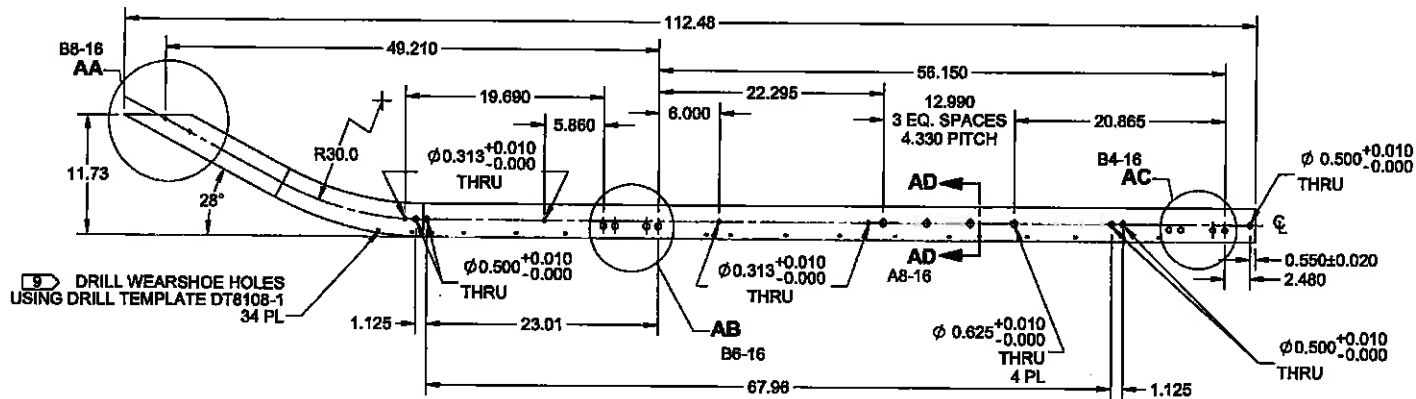
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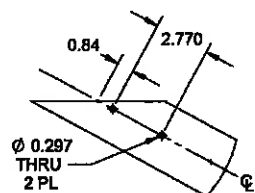
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DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 7 OF 11
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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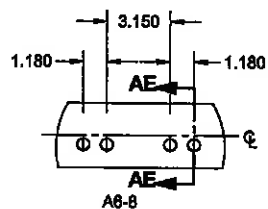


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEW LOOKING FWD)

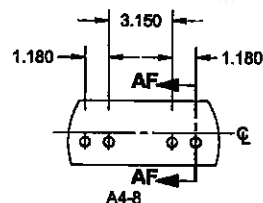
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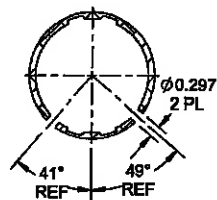
DETAIL AA
SCALE 2X



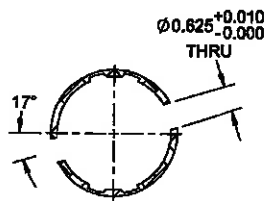
DETAIL AB
SCALE 2X



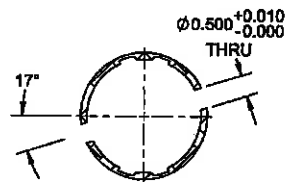
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 4X, 17 PL



SECTION AE-AE
SCALE 4X, 4 PL

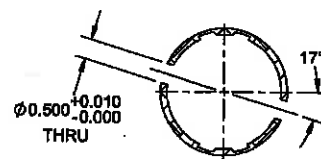
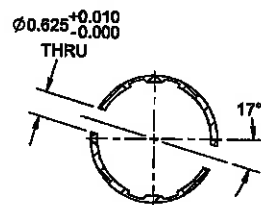
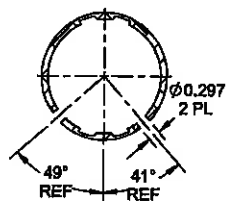
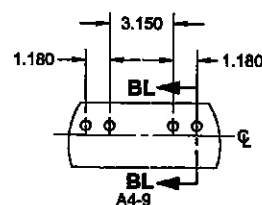
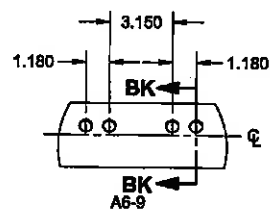
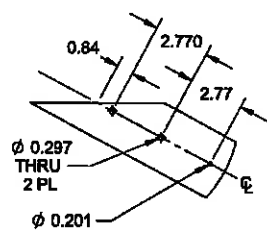
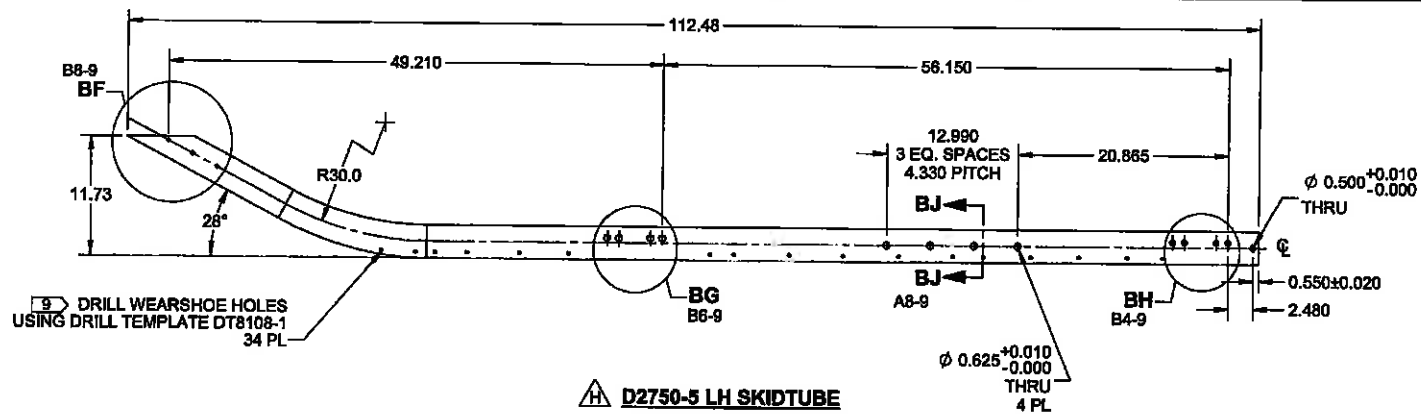


SECTION AF-AF
SCALE 4X, 4 PL

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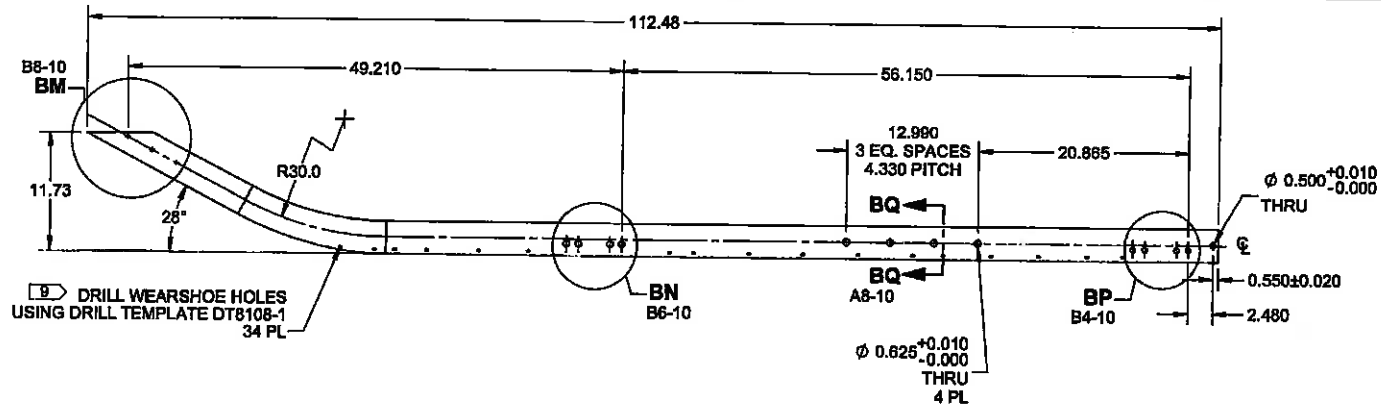
2018 OCT 19

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	CHECKED	MW	DRAWING NO.	REV. H
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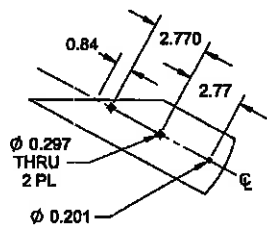


RELEASED
2019 OCT 19

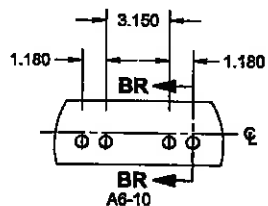
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DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 9 OF 18
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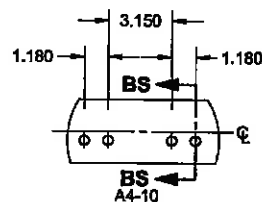
D2750-6 RH SKIDTUBE



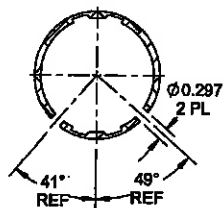
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SCALE 2X



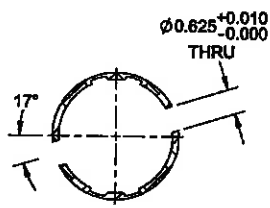
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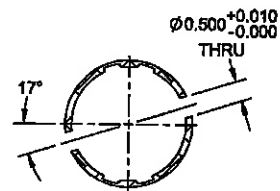
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SCALE 2X



SECTION BQ-BQ
SCALE 4X, 17 PL



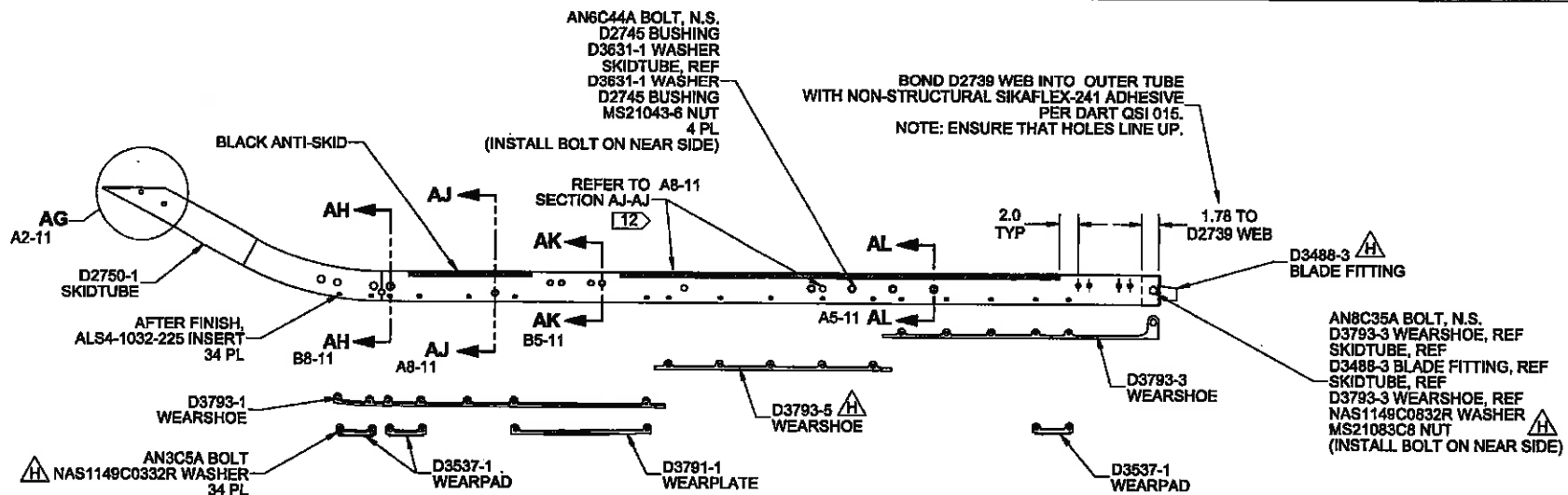
SECTION BR-BR
SCALE 4X, 4 PL



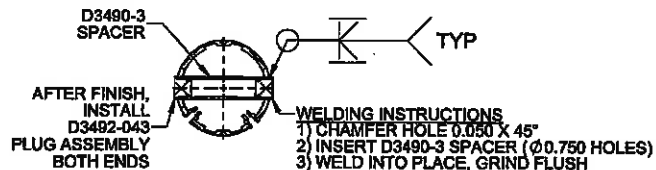
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2019 OCT 19

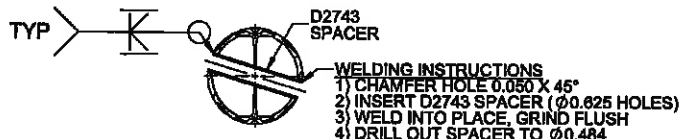
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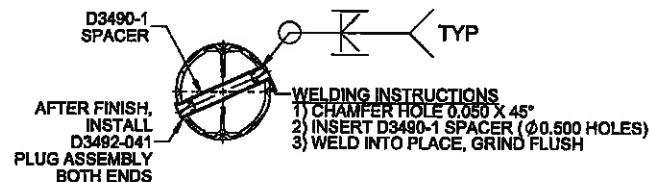
D2750-041 350 SKIDTUBE ASSEMBLY, LH



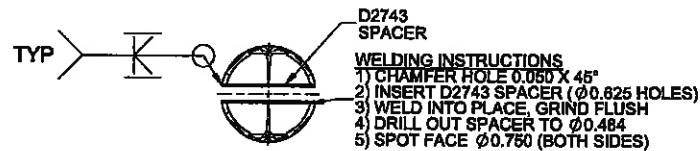
SECTION AH-AH
SCALE 3X, 4 PL



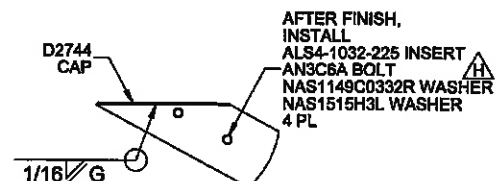
SECTION AK-AK
SCALE 3X, 4 PL



SECTION AJ-AJ
SCALE 3X, 4 PL



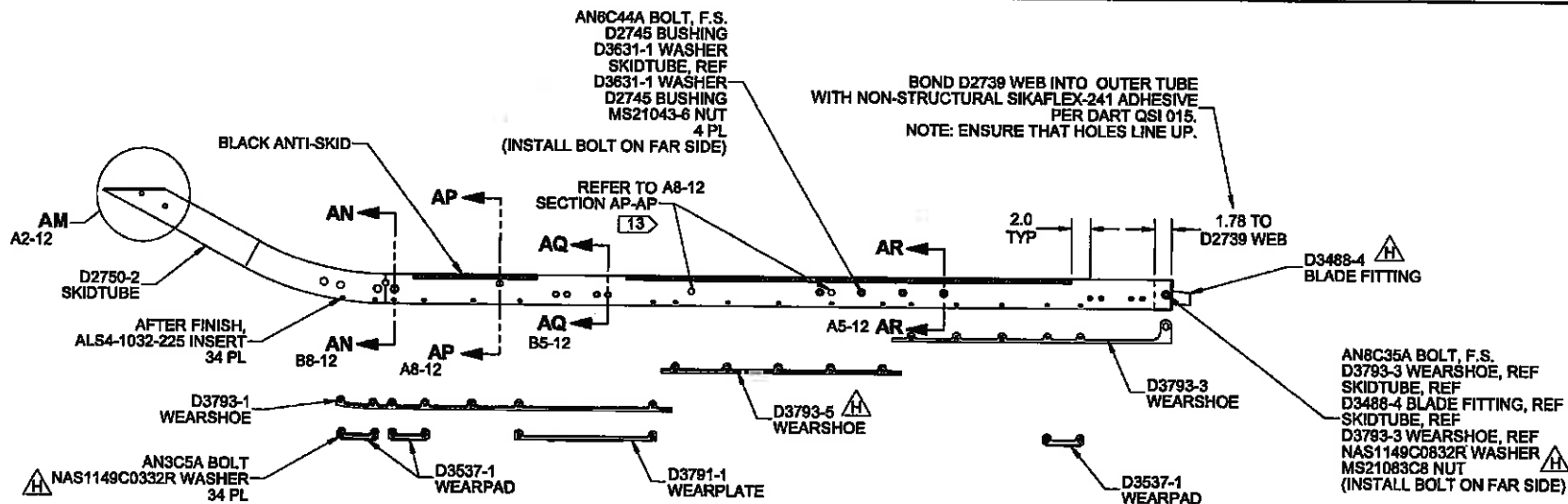
SECTION AL-AL
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



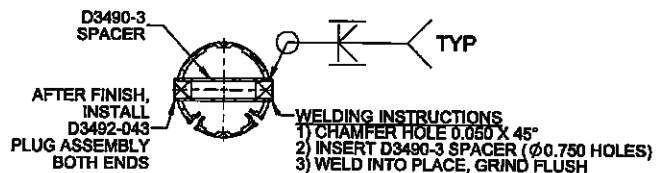
DETAIL AG
SCALE 2X

RELEASED
2018 OCT 19

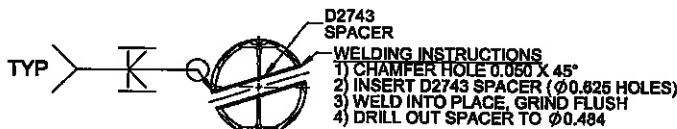
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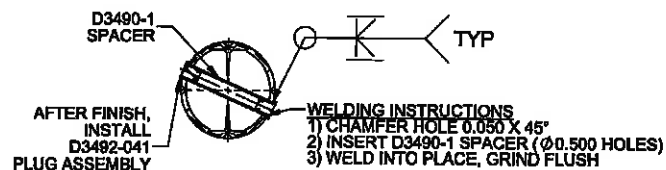
D2750-042 350 SKIDTUBE ASSEMBLY, RH



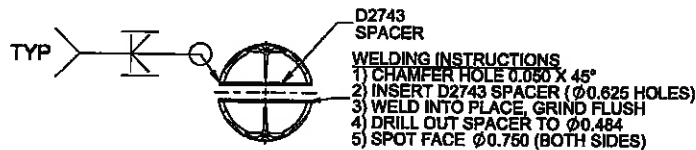
SECTION AN-AN
SCALE 3X, 4 PL



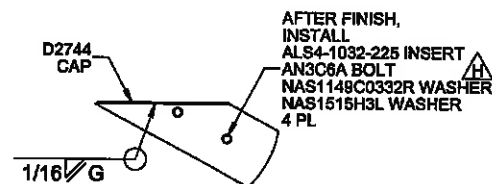
SECTION AQ-AQ
SCALE 3X, 4 PL



SECTION AP-AP
SCALE 3X, 4 PL



SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

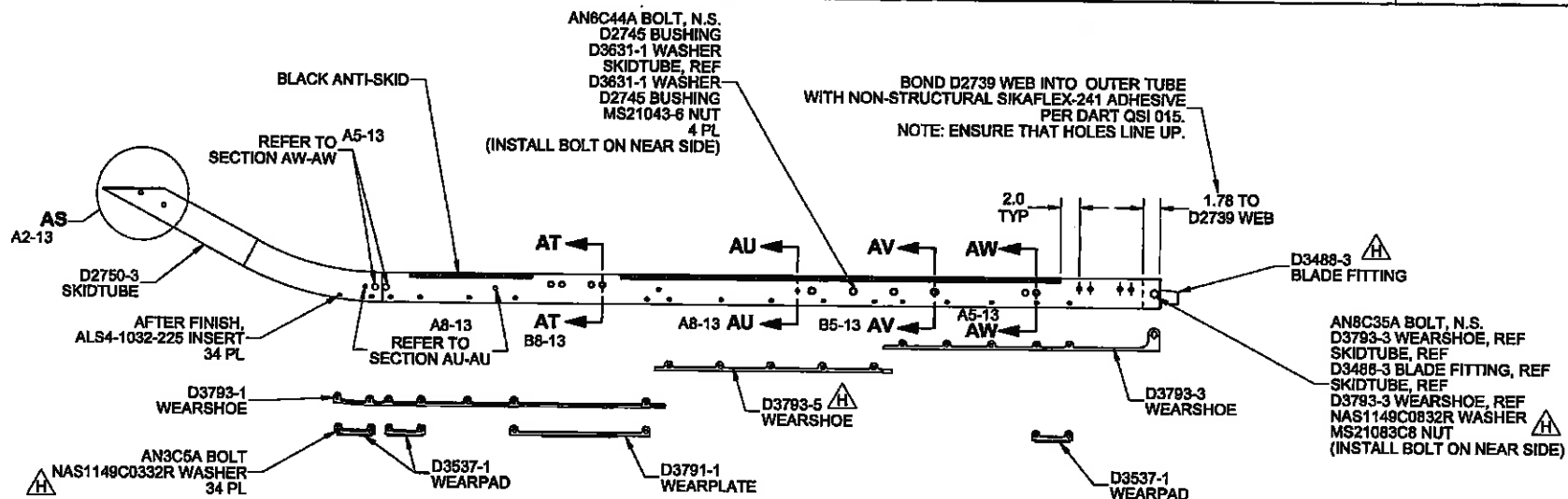


DETAIL AM
SCALE 2X

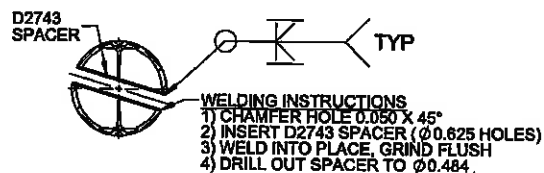
RELEASED

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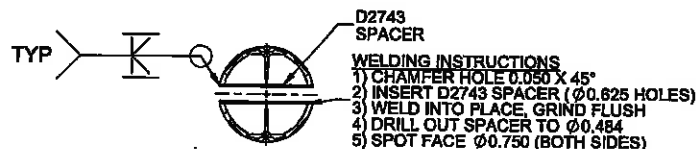
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	MFG. APPR.	DD	D2750	SHEET 12 OF 16
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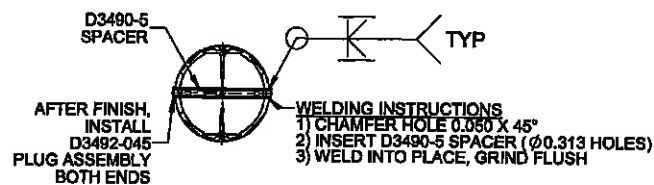
D2750-043 350 SKIDTUBE ASSEMBLY, LH



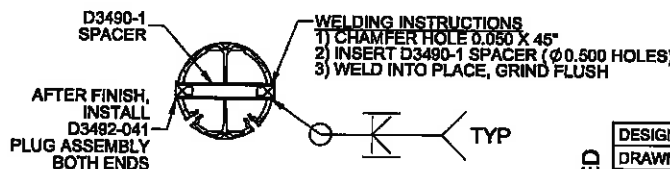
SECTION AT-AT
SCALE 3X, 4 PL



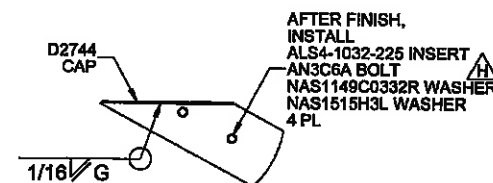
SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION AU-AU
SCALE 3X, 4 PL



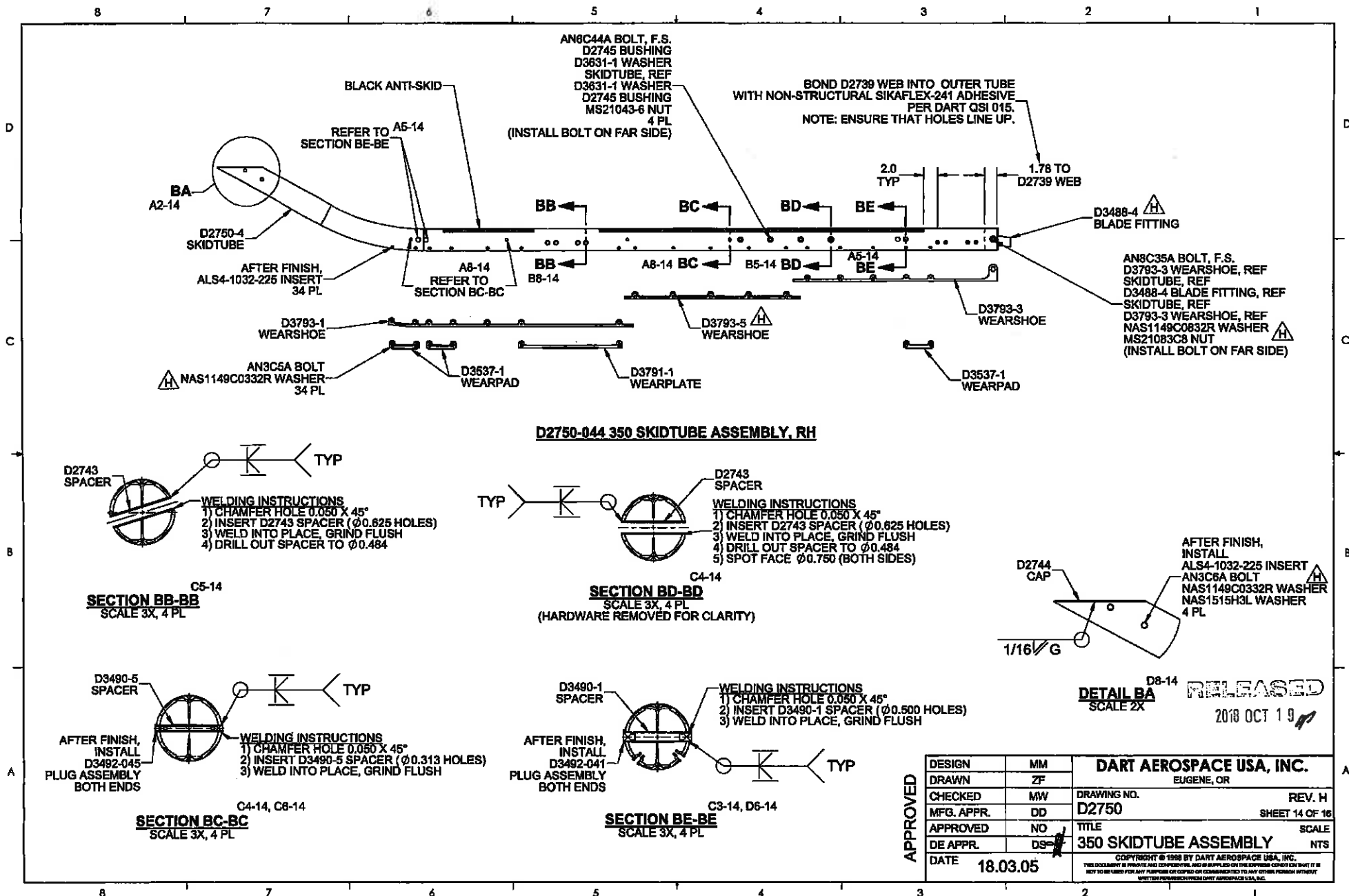
SECTION AW-AW
SCALE 3X, 4 PL



DETAIL AS
SCALE 2X

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8 7 6 5 4 3 2 1

D

C

B

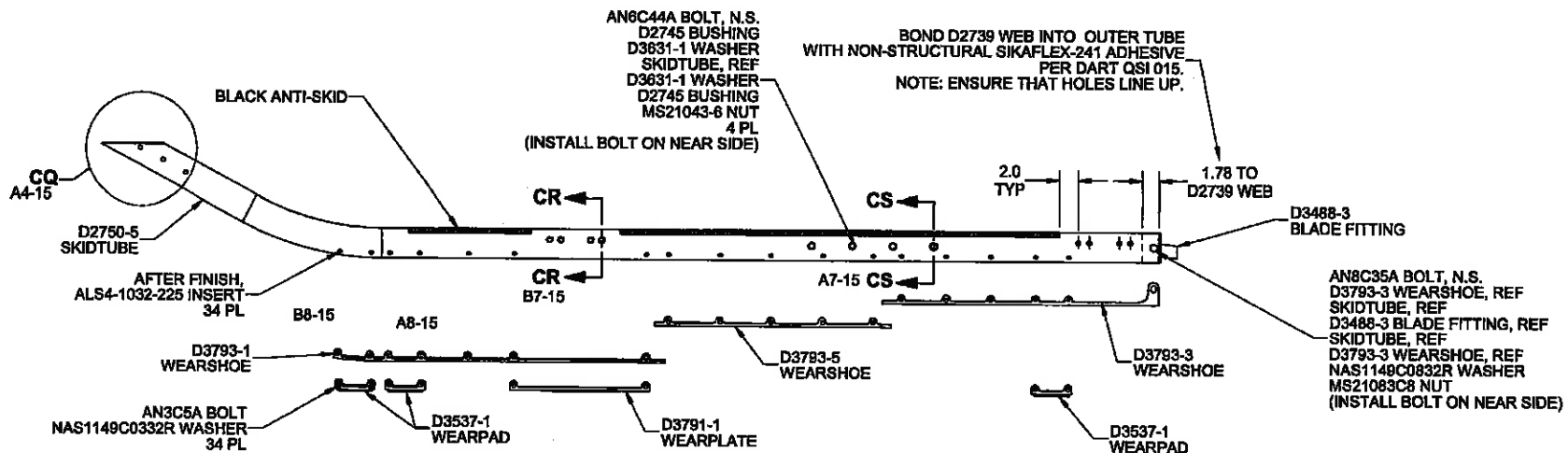
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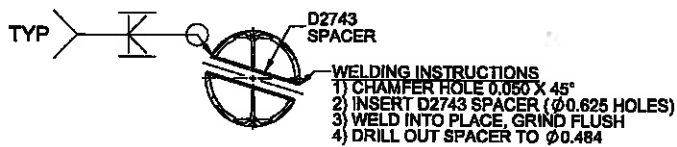
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B

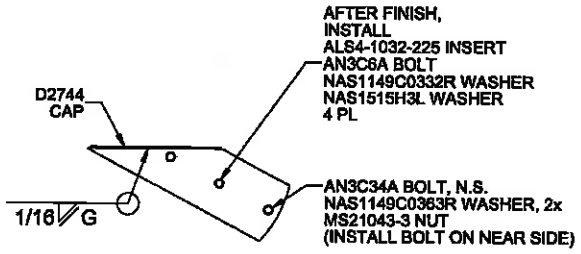
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D2750-051 350 SKIDTUBE ASSEMBLY, LH



SECTION CR-CR
SCALE 3X, 4 PL



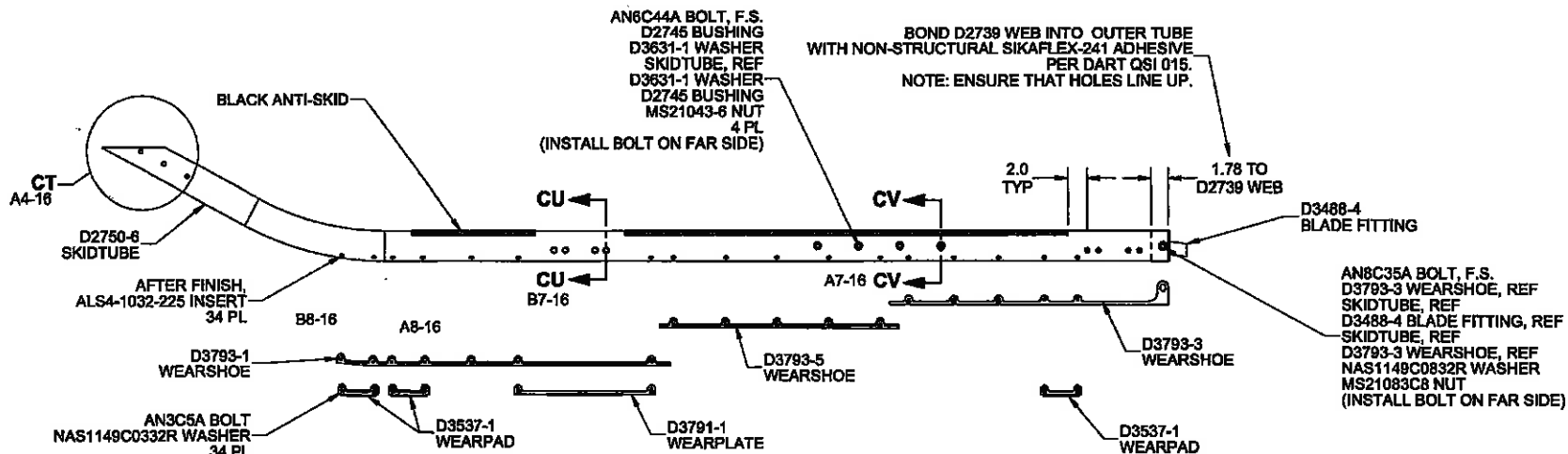
DETAIL CQ
SCALE 2X

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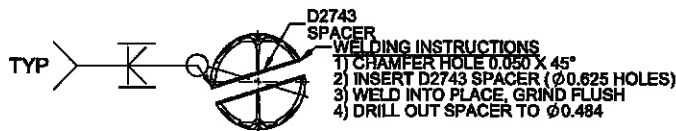


SECTION CS-CS
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(HARDWARE REMOVED FOR CLARITY)

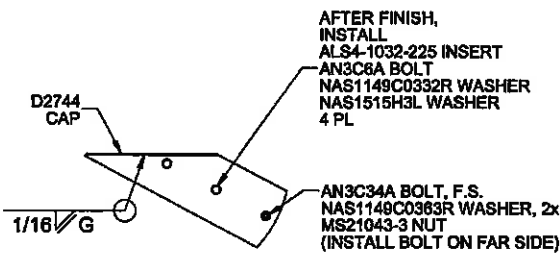
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	MFG. APPR.	DD	D2750	SHEET 15 OF 18
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D2750-052 350 SKIDTUBE ASSEMBLY, RH



SECTION CU-CU
SCALE 3X, 4 PL



DETAIL CT
SCALE 2X

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2018 OCT 19

SECTION CV-CV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

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Entered: 28 Date: SEP 16 2020



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-8463-

Route update only ☐

Job: <u>212300</u> Part No. <u>D2600-3-Bat RH</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☒ Cross tube ☐ Machining ☐ Small Fab ☐ Large Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Engineering ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐			
Date: <u>20.9.2</u>		Sequence #: <u>100</u>		QTY Affected: <u>4</u> <u>10</u>		MRB (QSI042) DAS 9 9-89 20-09-03	
Description Work Order Deviation				Disposition			
<u>4 tubes under Bat.</u> <u>RC; Process</u>				<u>Scrap & Replace</u> <u>Scrap x4 S214450</u> <u>Replace x4 S214450</u>			
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY ☐ Pressure/Forced ☐ Contamination ☐ Power Loss/Surge ☐ Positioned Wrong ☒ Bending ☐ Misaligned/off center ☐ Folio/Program ☐ Outside Tolerance ☐ Crushing ☐ BOM/Route ☐ Grain Direction ☐ Drawing ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Finish ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Marks/Chatter ☐ Drill Holes ☐ Out of Sequence ☐ Misread ☐ Mislabeled ☐ Fit/Function ☐ Off-set/Set-up			
				QC / QA Coordinator DAS 9 9-89 20-09-03			
				Other/Details:			